

Date: Friday, 05/12/2008 7:44:19 AM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MOUNTING CHANNEL
Job Number :	43922		
Estimate Number :	10605		
P.O. Number :		Part Number :	D2585
This Issue :	05/12/2008	Drawing Number :	D2585 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	B
Previous Run :	38813	Material :	
Written By :		Due Date :	12/12/2008
Checked & Approved By :	<u>CS02/12/05</u>	Qty:	40
Comment :	Est. D 04.02.16 Reformat; Add Receiving Step KJ/RF Est. C 06.07.21 waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304S14GA	304SS sheet .080
-----	-----------	------------------



Comment: Qty.: 0.0168 sf(s)/Unit Total : 0.6720 sf(s)

304SS .080

batch: 109358 18-08-12-8

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D2585

Dwg Rev: BProg Rev: B18-08-12-8

(45)

2-Deburr if necessary

05/12/08

(45)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

18-08-12-8**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK05/12/08

counters

(45)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr

Done at step #2.205/12/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/12/2008 7:44:19 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING CHANNEL

Job Number: 43922

Part Number: D2585

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Pb

Comment: NC BRAKE

Form as per Dwg D2585

SB 08/12/09 (44)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Counters

Comment: INSPECT WORK TO CURRENT STEP

SB 08/12/09 (44)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(44)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 37

8/12/09

SD

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2585 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: P Date: 08/12/10

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

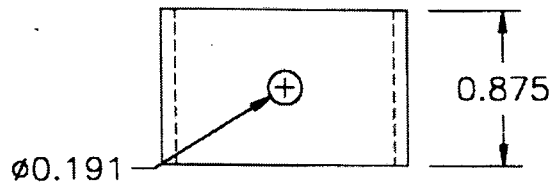
NCR: <u>43922</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/12/09</u>	<u>C</u>	<u>1 piece was out of tolerance first piece at the set up</u>	<u>[Signature]</u> <u>08/12/09</u>	<u>Scrap & destroy</u> <u>No replace.</u>	<u>SB</u> <u>08/12/09</u>	<u>[Signature]</u> <u>08-12-09</u>	<u>[Signature]</u> <u>08/12/09</u>	<u>[Signature]</u> <u>08/12-09</u>

NOTE: Date & initial all entries

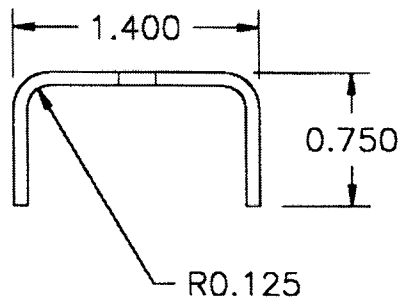


DESIGN BW	DRAWN BY [Signature]	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2585	REV. B SHEET 1 OF 1
DATE 96:07:11		TITLE MOUNTING CHANNEL	SCALE 1:1
B	97:03:14	ADD FLAT PATTERN	

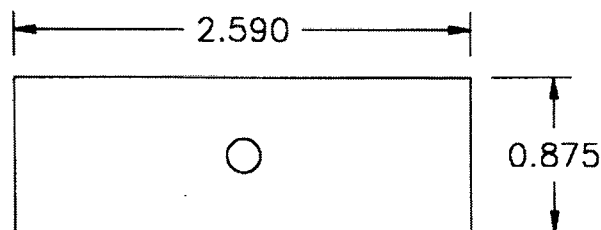
RELEASED
97/03/14 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43922



FLAT PATTERN



MATERIAL: 304/316 SS, 14 GAUGE (0.078)

DART AEROSPACE LTD	Work Order:	43922
Description: MOUNTING CHANNEL	Part Number:	D2585
Inspection Dwg: D2585, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	X	Prototype
----------	----------------------	----------	------------------

[illegible]

Measured by:	WB	Audited by:	S	Prototype Approval:	1/
Date:	8-17-5	Date:	06/2/03	Date:	1/5

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	